

Date: Monday, 31/03/2008 1:46:52 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 38254		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 31/03/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL/MED FAB	Drawing Revision	: C
Previous Run	: 37749	Material	:
Written By	: <u>28.03.31</u>	Due Date	: 07/04/2008 Qty: 16 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



2.7



Comment: Qty.: 0.1113 sf(s)/Unit Total : 1.7808 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 107513 B 8-3-31

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

B 8-3-31

(24)

2-Deburr if necessary

B 8-3-31

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-3-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 02/04/01 (24)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 07/04/01

(24)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38254

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
A/R 2059B Hardcoat

Batch

M107051

(24)

JP

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

08-04-02

SP

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 08-04-03

08/04/02

(24)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/04/02

(24)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 100442

BR 08-04-02

(24)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JP

08-04-02

(X24)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-26

JP

08-04-02

(X24)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

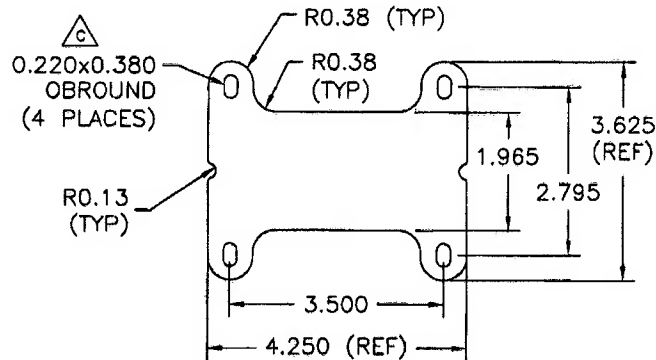
JA

Job Completion

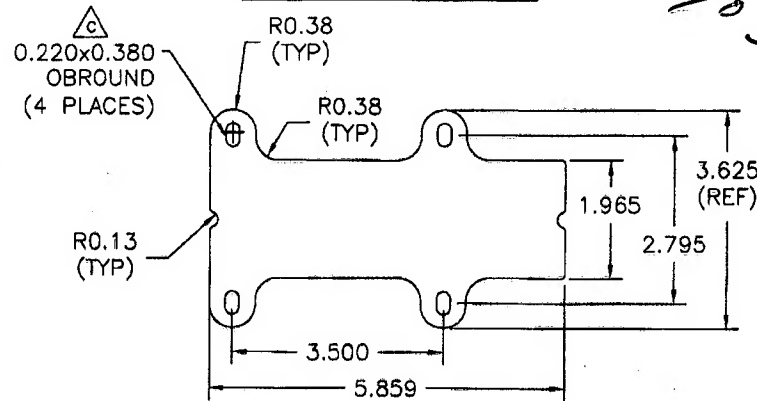


U 08-04-03

D3537-1F FLAT PATTERN

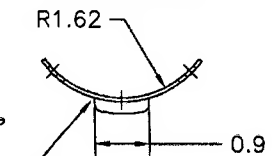


D3537-3F FLAT PATTERN



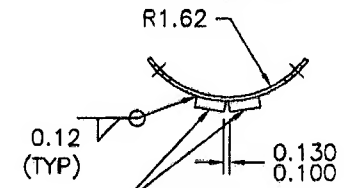
24/038254

SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

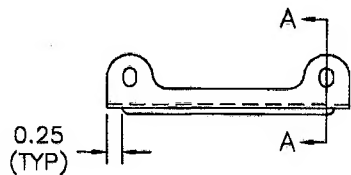
SECTION B-B



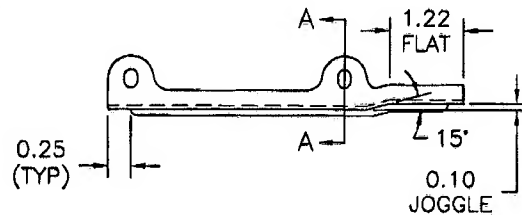
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07.05.08 Ad
per ECU 962

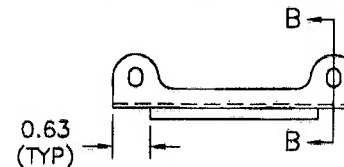
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



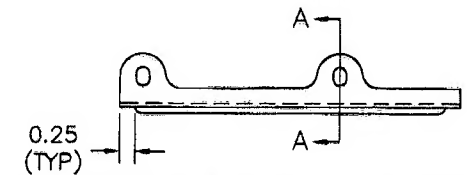
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY
CHECKED	4	APPROVED
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA